

Work Order ID 134776

134776

Page 1

Monday, July 20, 2015 2:41:26 PM

Item ID: D2611 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearing
 Start Date: 7/20/2015 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 7/20/2015 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: JUL 20 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2611	Rev C

100 PURCHASING 0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 2926 Purchase part as per Dwg D2611 Possible supplier:
 McMasterP/N: 63215K34 Material release note required

0.00

W 1507-21

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

Ensure certificate of conformity is attached

0.00

20x 8015-07-22

120 QC6- Inspect dimensions to drawing 0.00

120

QC

Quality Control

Memo

0.00

DAS
27
9-89

DAS
38
9-89

(20)

JUL 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																								
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Work Order ID 134776

134776

Page 2

Item ID: D2611 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearing
 Start Date: 7/20/2015 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 7/20/2015 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST 008A</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

20 JA JUL 24 2015
 15/1/27 48
 12015072-
 3/11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Monday, July 20, 2015 2:41:29 PM

Page 1

Work Order ID: 134776

134776

Parent Item: D2611

D2611

Parent Item Name: Bearing

Start Date: 7/20/2015

Required Date: 7/20/2015

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:B99.06.23Re-formatDM

Change to SS; Change Supplier- Rev.C 07.03.14 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
63215K34		Purchased			No		Each	0.0000		20			
63215K34									**				
Bearing													

20x 8/15-07-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

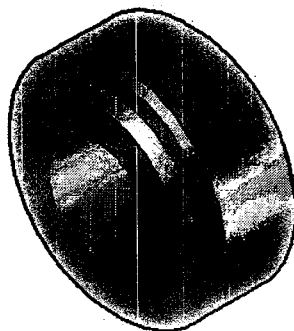
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																



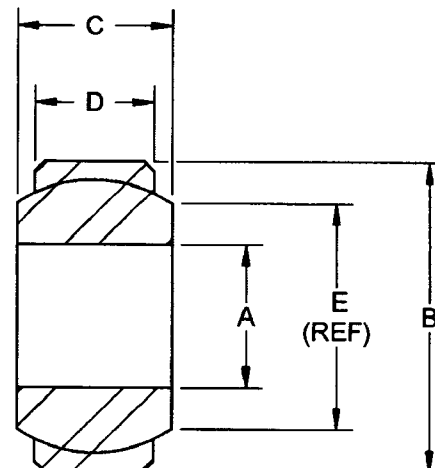
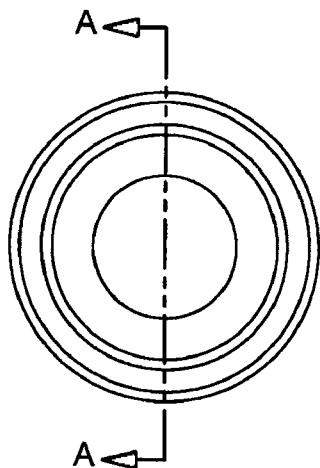
DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2611	REV. C SHEET 1 OF 1
DATE 06.09.20	TITLE BEARING SCALE NTS		
REV	DATE	DESCRIPTION	
A	97.07.31	NEW ISSUE	
B	01.07.04	RE-DRAWN	
C	06.09.20	CHANGE TO SS; CHANGE SUPPLIER	

SPECIFICATION CONTROL DRAWING



RELEASED

06.11.17 *#*



SECTION A-A

1347736-115
 1509-20
 ORDER
 NOTICE
 TO AMENDMENT
 ALL DIMENSIONS
 TO BE IN INCHES
 UNLESS NOTED
 OTHERWISE
 COPY
 TO
 DRAWING
 DEPARTMENT

A	B	C	D	E (REF)	POSSIBLE SUPPLIER
0.375	0.813	0.406	0.313	0.592	McMASTER-CARR P/N 63215K34

NOTES:

- 1) STAINLESS STEEL BALL JOINT SWIVEL BEARING
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29216**

Purchase Order Date 7/21/2015

PO Print Date 7/21/2015

Page Number 1 of 3

Order From :

VU-MCM001

Ship To : DART AEROSPACE LTD

MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 330 995 5500

Ship To Contact

Ship To Phone

Ship Via: Purolator ground ppd

Ship Acct:

Buyer

Linda Lacelle

Customer POID

Customer Tax # 10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	59915K274 PER DRWG D4777 REV.A MCMASTER P/N 59915K274	Rod End Bearing	7/24/2015 Yes 7/24/2015		8.00 Each	\$17.14	\$137.12
Line Total:							\$137.12
2	63215K34 PER DRWG D2611 REV.C MCMASTER P/N 63215K34	Bearing	7/24/2015 Yes 7/24/2015		20.00 Each	\$17.24	\$344.80
Line Total:							\$344.80
3	92311A564 PER DRWG D3533 REV.B MCMASTER P/N 92311A564	Set Screw	7/24/2015 Yes 7/24/2015		50.00 Each	\$0.23	\$11.65

Note:

7/21/2015

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO29216
Order Placed By
Linda Lacelle

Page 1 of 1
07/21/2015

McMaster-Carr Number
6243600-02

Line	Product	Ordered	Shipped
1	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread	8 Each	8 ✓
2	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick	20 Each	20 ✓
3	92311A564 18-8 Stainless Steel Cup Point Set Screw, 1/4"-28 Thread, 1" Long, Packs of 50	1 Pack	1 ✓
4	92311A639 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long, Packs of 10	10 Packs	10 ✓
5	7566K25 Cable Tie Mount, Adhesive/Fastener Mount, 4 Way, 0.21" Tie WD. , White, Packs of 50	1 Pack	1 ✓

Shipped separately from our Chicago warehouse on 07/21

6	3543T77 High-Strength 301 Stainless Steel Sheet, with Certificate, Full Hard, 0.029" Thick, 12" X 36"	1 Each	1
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Certificate of compliance

This is to certify that the above items were supplied in accordance with the description and as illustrated in the catalog. Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.

Sarah Weinberg
Sarah Weinberg
Compliance Manager

SP15-07-22